

Work Order ID 73356



Page 1

Wednesday, August 31, 2011 11:38:12 AM

| | | | | | | |
|----------------|----------------------------|------------|------|-------|---------------|--|
| Item ID: | D4030-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Long Basket Assembly (350) | | | | | |
| Start Date: | 8/31/2011 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 9/12/2011 | Req'd Qty: | 1.00 | | Customer: | |

Reference:

| | | | | | | | | | | | |
|------------|---------------|-----------|-------|-----------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <u>CL</u> | Date: | <u>11/08/31</u> | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| D4030 | C | | | | | | | | |

| | | | | | | | | | |
|-----------|----------|------|--|--|--|--|--|--|--|
| 100 | Pick Kit | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

SP SP 11-09-26

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 110 | Assemble as per dwg | 0.00 | | | | | | | |
| | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | ****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label **** | | | | | | | | |

1 d M 11/09/29

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Su 10/2/30

FD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PDP 73352

0.00

Packaging

Cap 30

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK u/09/30

MF

11-09-30

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Work Order ID: 73356

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)



Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------------|--|--------------|----|--|--|--|------|--------|--|---|--|--|--|
| D4086-210 | | Manufactured | No | | | | Each | 9.0000 | | 1 | | | |
|---------------|--|--------------|----|--|--|--|------|--------|--|---|--|--|--|

Placard, Max Load

Location Loc Qty Loc Code

ST122 8

66275 8

ST124 1

64869 1

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|--|---|--|--|--|
| D2530 | | Manufactured | No | | | 100 | Each | 11.0000 | | 1 | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|--|---|--|--|--|

Handle Weldment

Location Loc Qty Loc Code

ST506 10

72166 10

ST508 1

69318 1

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|--|---|--|--|--|
| D2535 | | Manufactured | No | | | 100 | Each | 85.0000 | | 2 | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|--|---|--|--|--|

Spring

Location Loc Qty Loc Code

ST504 85

71117 85

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73356

Parent Item: D4030-041


Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No 100 Each 29.0000

 Bushing



2

2

Location

Loc Qty


Loc Code

ST504

29

71853


29

D3913-041 Manufactured No 100 Each 0.0000

 Long Basket Base Assembly, 350



1


1

D3914-041 Manufactured No 100 Each 0.0000

 Long Basket Lid Assembly (350)



1

1

D3917-3 Manufactured No 100 Each 13.0000

 Washer



6

6

Location

Loc Qty


Loc Code

ST092

13

72142

13

D3953-3 Manufactured No 100 Each 16.0000

 Gas Spring Stud, Lid



2

2

Location

Loc Qty

Loc Code

ST096

16

71875

16

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Work Order ID: 73356

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each

13.0000

2



Spring Spacer

Location

Loc Qty

Loc Code

ST096

13

65053

4

71885

9

D3953-9 Manufactured No

100 Each

16.0000

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST096

16

69025

4

71869

12

D3953-17 Manufactured No

100 Each

4.0000

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST096

4

71870

4

D3953-19 Manufactured No

100 Each

4.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST096

4

59213

1

68462

3

①
B741688

1X
2
B741698

2
B73474

1
11-09-26

1X

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | | | | | |
| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Work Order ID: 73356

Parent Item: D4030-041





Parent Item Name: Long Basket Assembly (350)




Start Date: 8/31/2011




Required Date: 9/12/2011


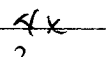

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|---|--------------|----|-----|------|--------|---|---|
| D3953-21 | Manufactured | No | 100 | Each | 3.0000 | 1 | 1 |
|  | | | | | |  |  |
| Gas Spring Bracket | | | | | | |  |

| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | |
|---|--------------|----|-----------------|----------------|-----------------|---|---|
| D3969-3 | Manufactured | No | ST096 | 3 | | 1 | |
|  | | | <u>68463</u> | 3 | | 1 |  |
| Spring (Basket Lid) | | | | | 4.0000 | |  |

| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | |
|---|-----------|----|-----------------|----------------|-----------------|---|---|
| AN3-14A | Purchased | No | ST272 | 4 | | 4 | |
|  | | | 64285 | 1 | | 4 |  |
| Bolt | | | <u>68925</u> | 3 | | |  |

| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | |
|---|-----------|----|-----------------|----------------|-----------------|---|---|
| AN3-16A | Purchased | No | ST352 | 76 | | 2 | |
|  | | | <u>117872</u> | 76 | | 2 |  |
| Bolt | | | | | 173.0000 | |  |

| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | |
|--|--|--|-----------------|----------------|-----------------|--|---|
| | | | ST352 | 173 | | | |
| | | | <u>117441</u> | 73 | | |  |
| | | | <u>118628</u> | 100 | | | |

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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73356

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 100 Each 114.0000 4 4
Bolt

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST337 | 20 | |
| 118422 | 20 | |
| ST339 | 94 | |
| 117872 | 44 | |
| 118706 | 50 | |

AN4-12 Purchased No 100 Each 72.0000 3 3
Bolt

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST357 | 72 | |
| 117514 | 22 | |
| 118626 | 50 | |

AN310-4 Purchased No 100 Each 39.0000 3 3
NUT

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST324 | 39 | |
| 118112 | 39 | |

AN310C4 Purchased No 100 Each 47.0000 2 2
Nut

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST324 | 47 | |
| 116741 | 4 | |
| 117395 | 13 | |
| 118090 | 10 | |
| 118626 | 20 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73356

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,777.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

1777

117441

160

117601

400

117885

217

118451

1000



SP - 5

MS21042L5

Purchased

No

100

Each

1,076.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

1076

116105

5

116548

53

117441

432

117611

90

118179

496



SP 5

MS24665-151

Purchased

No

100

Each

418.0000

3

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

418

17566

418



SP 11-09-26

3x

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID: 73356

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

248.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

48

116823

48

NAS1149F0432P

Purchased

No

100

Each

82.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST275

82

117291

8

118612

74

NAS1149F0563P

Purchased

No

100

Each

180.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST297

180

117735

180

NAS1149F0332P

Purchased

No

100

Each

174.0000

8

8



WASHER

Location

Loc Qty

Loc Code

ST275

174

117735

75

118354

96

17317

3

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| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID: 73356

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,542.000

2

2



Washer

SP 11-09-26

Location

Loc Qty

Loc Code

ST297

4542

117291

4542

2x

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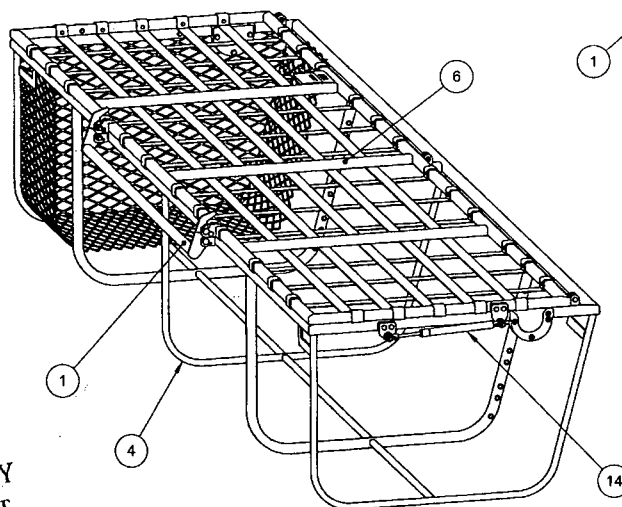
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

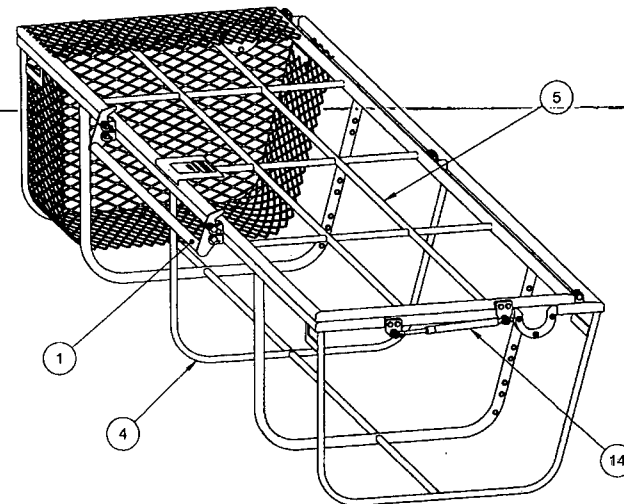
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NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|---------------|-----------------------------------|
| | X | | D4030-041 | LONG BASKET ASSY (350) |
| | | X | D4030-043 | LONG BASKET ASSY, LIGHT LID (350) |
| 1 | 1 | 1 | D2530 | HANDLE WELDMENT |
| 2 | 2 | 2 | D2535 | SPRING |
| 3 | 2 | 2 | D2537 | BUSHING |
| 4 | 1 | 1 | D3913-041 | LONG BASKET BASE ASSY (350) |
| 5 | 1 | | D3914-041 | LONG BASKET LID ASSY (350) |
| 6 | | 1 | D3915-041 | LIGHT LID ASSY-LONG BASKET |
| 7 | 6 | 6 | D3917-3 | WASHER |
| 8 | 2 | 2 | D3953-3 | GAS SPRING STUD, LID |
| 9 | 2 | 2 | D3953-7 | GAS SPRING SPACER |
| 10 | 2 | 2 | D3953-9 | GAS SPRING WASHER |
| 11 | 2 | 2 | D3953-17 | GAS SPRING SPACER |
| 12 | 1 | 1 | D3953-19 | GAS SPRING BRACKET |
| 13 | 1 | 1 | D3953-21 | GAS SPRING BRACKET |
| 14 | 1 | 1 | D3969-3 | SPRING |
| 15 | 4 | 4 | AN3-14A | BOLT |
| 16 | 2 | | AN3-16A | BOLT |
| 17 | | 2 | AN3-20A | BOLT |
| 18 | 3 | 3 | AN4-12 | BOLT (DRILLED) |
| 19 | 4 | 2 | AN5-17A | BOLT |
| 20 | | 2 | AN5-21A | BOLT |
| 21 | 3 | 3 | AN310-4 | NUT, CASTELLATED |
| 22 | 2 | 2 | AN310C4 | NUT, CASTELLATED |
| 23 | 6 | 6 | MS21042L3 | NUT |
| 24 | 4 | 4 | MS21042L5 | NUT |
| 25 | 3 | 3 | MS24665-151 | COTTER PIN |
| 26 | 2 | 2 | MS24665-300 | COTTER PIN |
| 27 | 6 | 6 | NAS1149F0432P | WASHER |
| 28 | 4 | 4 | NAS1149F0563P | WASHER |
| 30 | 8 | 8 | NAS1149F0332P | WASHER |
| 31 | 2 | 2 | NAS1149C0432R | WASHER |



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13356
C211108/31

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10-08-12
ECN 10-596

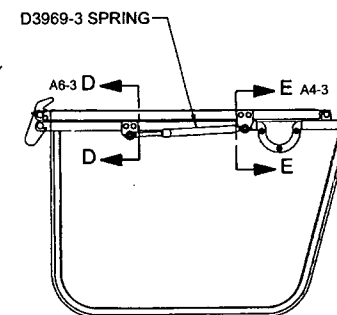
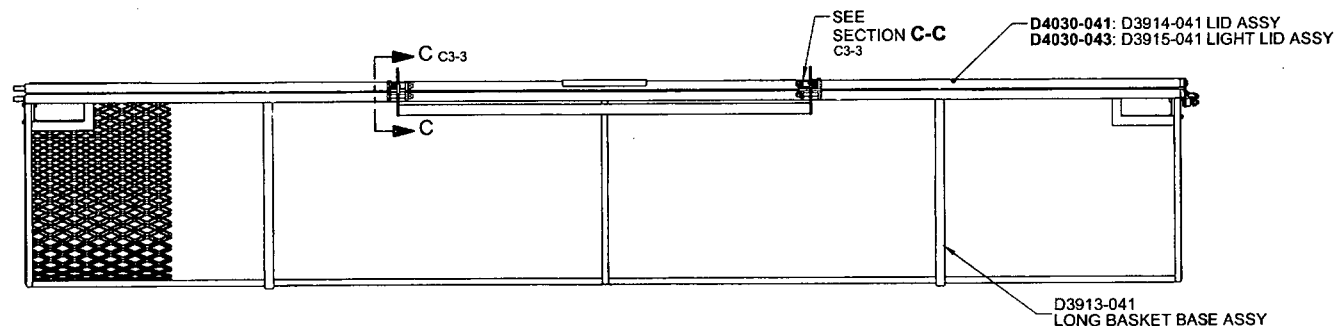
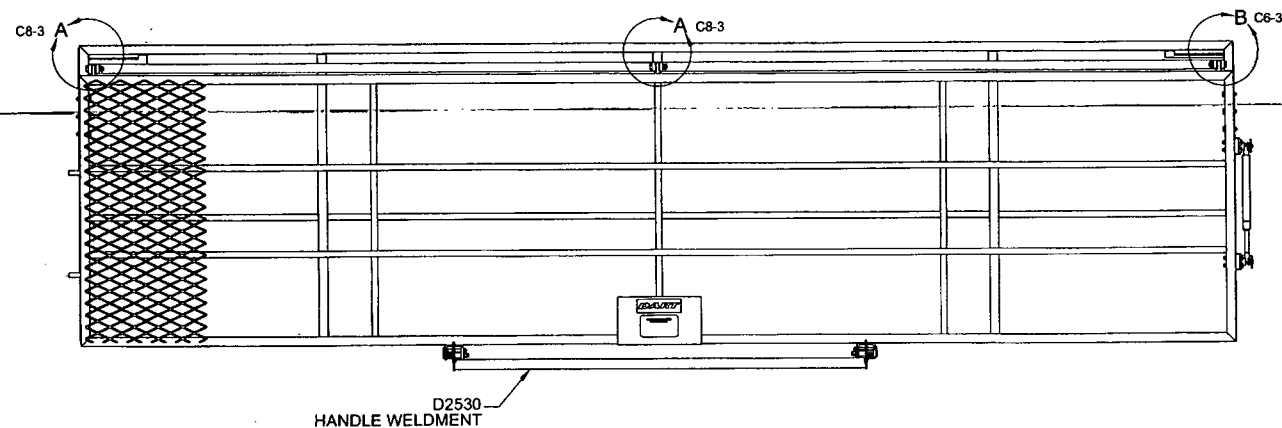
| | | | |
|------------|--|-----|----------|
| C | QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3). | MB | 10.07.23 |
| B | AN5-21A BOLT WAS AN5-19A: BOM & (D3-3) | JPH | 10.04.06 |
| A | NEW ISSUE | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AS | | |
| DRAWN | AS | | |
| CHECKED | AS | | |
| MFG. APPR. | JFS | | |
| APPROVED | AS | | |
| DE APPR. | AS | | |
| DATE | 10.07.23 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030** REV. C
SHEET 1 OF 3
TITLE **LONG BASKET ASSY (350)** SCALE NTS

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8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

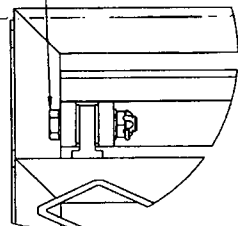
D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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10.08.17

| | | | |
|------------|----------|---|--------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | SES | D4030 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET ASSY (350) | NTS |
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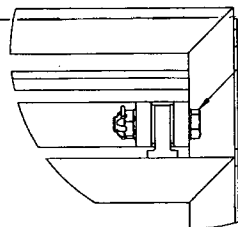
8 7 6 5 4 3 2 1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



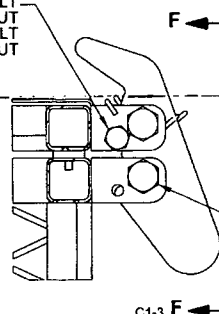
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

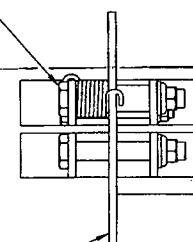


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

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| | | | |
|--|----------|--|--------------|
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| MFG. APPR. | JFS | D4030 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET-ASSY (350) | NTS |
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